Work Orde				*96	579*							Page 1
Item ID: Revision ID:	D3121-23		A	Accept	*N900)040	100)* s	Setup	Start	*N:	S1*
Item Name:	Bearing		100							Stop	*N:	S2*
Start Date:	1/29/13	Start Qty: 60.00	*6A*		Cust Item	ID:						
Required Date: Reference:	2/20/13	Req'd Qty: 60.00	*60*		Customer	:						
Approvals:	Process Pla	in: ML5	Date: 13-01-31	Tooling:		Date:	_	F	Run	Start	*N	R1*
• •			Date:			Date:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3121	Rev	Е			•					•		
100				0.00								
100		PURCHASING						\mathcal{C}_{λ}	(13	3 /m	alu	100
Purchasing		Memo	iC-c 7	0.00					· · · · · · · · · · · · · · · · · · ·	<i>3</i>	~	,
Purchasing		Issue P/O: _ SKF P/N: 61	19067 Bearing as pe 1900-2Z or KML P/N: 6900-	er Dwg D3121Possibl ZZMaterial release no	le Supplier: ote is required							
110		Receive & Inspect for Da	amage & Mat'l Certs	0.00				i				
<u>*110*</u>								(00)	۷			
Packaging		Memo	onial Dalacca Nata is attached	0.00				(–			سر	
Packaging		Ensure Mate	erial Release Note is attached	u)	3-2-1
120		QC6- Inspect dimension	s to drawing	0.00 Sh	B			iac				
120		Memo		0.00 13 2	1.14			100				
~ -		MEHIO		O	` ' }							

Inspect diimensions as per Dwg D3121 and attached certfication Dwg Rev ____

Quality Control

NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
											QA Closed:	Dat	te:	
Work Ord	er.					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS		
Work Ord	٠					Rework	1		Skid-tube Crosstube	\neg		Water Jet		Engineering
Part I	No.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.		Quality
	•					Use-as-is		Therm	noforming Finishing		Rec/Sto	e/Packaging		Other
NCR I	No.			-		Work Order Update]		Large Fab Composite			Supplier		
Root					Descri	ption of work order update		Initial	Action		Sign &	· · · · · · · · · · · · · · · · · · ·		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verification	n	QC Inspector
Doc/Data														
Equip/Tooling	Ш						İ							
Operator										į				
Material	Ш													
Setup														
Other														
Process	Ш			·										
Supplier			-				l							
Training	Ш				•									
Unapproved										_				
						F	AUL	LT CATE	GORY					
Landi	ing C	Gear			_	General		-		_	٦		_	7
		Bending				Bend	L	Grain		L	Ovalized		L	Pressure/Forced
		Centre No	ot Concei	ntric to (o/s	BOM/Route		Hardwa	re	L	Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged	L	Inspect	on Incomplete	L	Part Incorre	ct	_	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Unclear	L	Part Lost/M	issing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance	L	Part Moved			
		Heat Trea	it			Countersink		Mislabe	elecl		Positioned \	Vrong		_
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss,	'Surge		Other
		Ripples in	Bend		Г	Drill Holes		Offset			=			

Out of Calibration
Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

	Work Order ID 96579 anuary-31-13 10:44:06 AM			*965					Page 2			
Revision ID:	D3121-23 Bearing			Accept	*N900	040	100	ን* ፡	Setup S	Start Stop		S1* S2*
Start Date: Required Date: Reference:	1/29/13 2/20/13	Start Qty: 60.00 Req'd Qty: 60.00	*60* *60*		Cust Item I	D:					7 4 4	
Approvals:	Process Pla	an:	Date:	_		ate:]		Start Stop		R1* R2*
Sequence ID/ Work Center II 130 *130* Packaging Packaging)	Operation Description Identify as per dwg & Sto	ock Location	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty /6GX	Rejec Qty		Reject Number	Insp. Stamp
140 *140* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00					/	13/	- lu	1 4
											(:	WF 3-2-14

												DQA:	Dat	:e:	* e.
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPE	DATE		-		_	
											(QA Closed:	Dat	:e:	
144 1. Od			-			DISPOSITION AGAINST DEP			ΞP	ARTMENT/	PROCESS				
Work Ord	er: -					Rework			Skid-tube	Crosstube	7		Water Jet	\neg	Engineering
Part I	No.					Scrap		i	Machining	Small Fab	1	Prod	d. Eng. Coor.	\dashv	Quality
	-					Use-as-is			noforming	Finishing	1		e/Packaging		Other
NCR I	No.					Work Order Update			Large Fab	Composite			Supplier		
											_				····
Root					1	otion of work order update	ł	nitial	Act			Sign &		ļ	
Cause	_	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	iption	\downarrow	Date	Verification	1	QC Inspector
Doc/Data	Ш										1			1	
Equip/Tooling													•		
Operator	Ш										1			- 1	
Material	Ш								- -		١			1	
Setup	Ш														
Other	Ш										١				
Process											١				
Supplier	Ш										1				
Training	Ш														
Unapproved							<u> </u>								
							AUL	T CATE	GORY					—	
Landi		1				General		1			_	O 11 1	1	_]
	-	Bending	_			Bend	-	Grain		_	-	Ovalized	4.1	⊢	Pressure/Forced
	-	Centre No	ot Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa			-	Over/Under		├	Temperature/Cure
	\vdash	Cracks				Broken/Damaged	_	∔ `	ion Incomplete	-	-1	Part Incorred		\vdash	Weld
	-	Crushed/	Crimped,		<u> </u>	Burrs	<u>_</u>	4	ions Incomplete/l	Jnclear	-	Part Lost/Mi	ssing	<u></u>	Wrong Stock Pulled
		Cuffs				Contamination	<u></u>	Mainte		 -	-1	Part Moved			
	Ш	Heat Trea	it		<u> </u>	Countersink	_	Mislabe		<u> </u> _	-1	Positioned V	·		1 .
l	Inspection Strip in Tube		Cut Too Short	1	Misread	4		- [Power Loss/	Surge	1	Other			

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

Picklist Print

January-31-13 10:44:06 AM

Work Order ID:

96579

Parent Item:

D3121-23

Parent Item Name:

Bearing

Start Date: 1/29/13

Start Qty: 60.00

Required Date: 2/20/13

Required Qty: 60.00

Comments:

IPP A: 04.02.19 New Issue KJ/DS

IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6900ZZ		Purchased	No			100	Each	0.0000	1	60,	20 (
Bearing									·		00 X		

SP13-2-13;

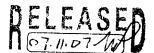
NCR:	Yes	/	No

DQA: _____ Date: ____

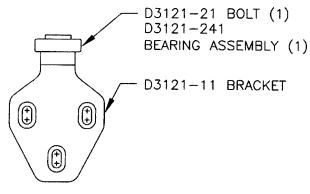
NCR: Ye	es / No				WORK ORDER NON-	CONFOR	MANCE / UP		QA Closed:	Date	:
Work Orde	r•				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is	- I	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	0				Work Order Update] '''e''	Large Fab	Composite	Nec/3tol	Supplier	
Root					ption of work order update	Initial		tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data									,		
quip/Tooling	_								:		
Operator											
Material Setup	_										
Other	\dashv										
Process	┪										
Supplier											
Training											
Unapproved	7										
-					F	AULT CATE	GORY				
Landin	g Gear				General			_	1	_	
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	Hardw		<u> </u>	Over/Under	<u> </u>	Temperature/Cure
	Cracks			_	Broken/Damaged		tion Incomplete		Part Incorre	<u></u>	Weld
-	Crushed/	Crimped.		_	Burrs		tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
-	Cuffs			ļ	Contamination	\vdash	enance	-	Part Moved Positioned \	Mrong	
}	Heat Trea		Tuka	-	Countersink Cut Too Short	Mislab Misrea			Power Loss/		Other
-	Inspectio Ripples in		rube	-	Drill Holes	Offset	u	<u> </u>	J. O.M.C. 1033/	Juige	Totales
-	Torque W		Extrusion	, H	Drawing		Calibration				
-	Turning S			' 	Finish		Out of Sequence				
1	Wave/Tw				Folio	—	e Dimensions				



3N #	DRAWN BY	DART AEROSP, HAWKESBURY, ONTARI	
CKED	APPROVED	DRAWING NO.	REV. E
#		D3121	SHEET 1 OF 10
		TITLE	SCALE
11.07		BRACKET ASSEMBLY	1:2
	02.04.15	NEW ISSUE	
	03.01.16	ADD RIDGES; ADD MAT'L ADD -141/-143/-144,	PROP; FIX P/N /-145/-146
	04.02.17	ADD CLEARANCE; USE -	241 BEARING
	CKED#	APPROVED APPROVED 11.07 02.04.15 03.01.16	DART AEROSP, HAWKESBURY, ONTARI DRAWING NO. D3121 TITLE BRACKET ASSEMBLY 02.04.15 NEW ISSUE 03.01.16 ADD RIDGES; ADD MAT'L ADD -141/-143/-144,

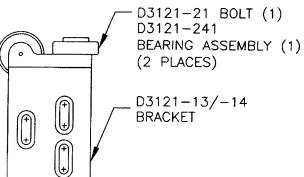


			1.2
Α	02.04.15	NEW ISSUE	
В	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P, ADD -141/-143/-144/-145/-146	/N
С	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.00	00
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	
	С	B 03.01.16 C 04.02.17 D 06.05.17	B 03.01.16 ADD RIDGES; ADD MAT'L PROP; FIX PADD -141/-143/-144/-145/-146 C 04.02.17 ADD CLEARANCE; USE -241 BEARING D 06.05.17 D3121-25 CAP WAS 1.024, NOW 1.00



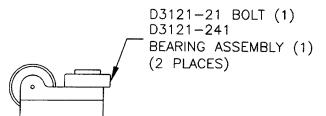
D3121-041 BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-37/-38)



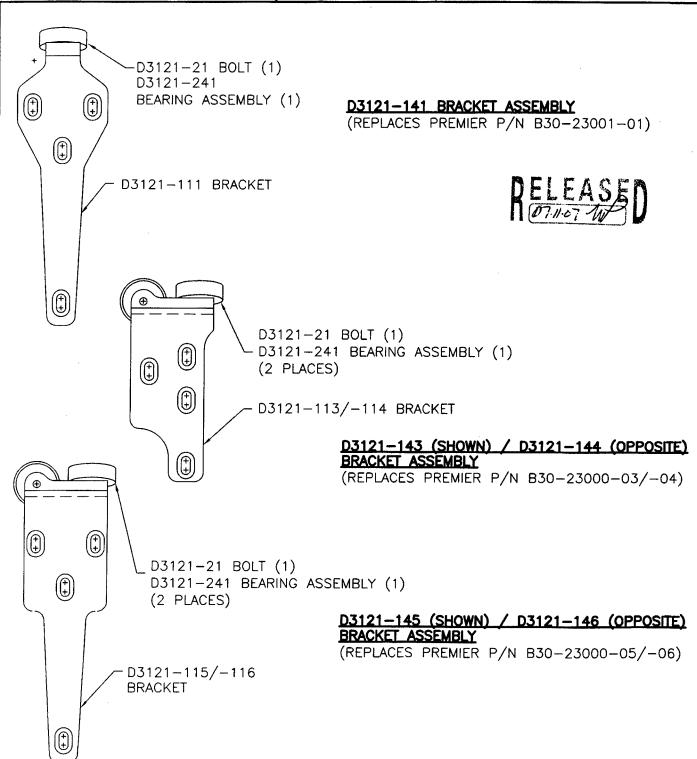
D3121-15/-16 BRACKET

D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-35/-36)



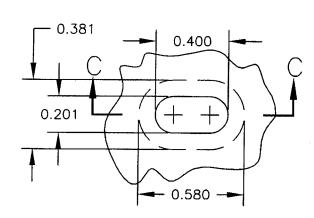
DESIGN	DRAWN BY	DART AEROSI HAWKESBURY, ONTA	
CHECKED	APPROVED	DRAWING NO.	REV. E
4		D3121	SHEET 2 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2

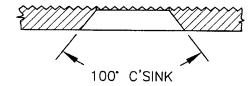




DESIGN	DRAWN BY	DART AEROS HAWKESBURY, ONT	
CHECKED	APPROVED	DRAWING NO.	REV. E
91	-M	D3121	SHEET 3 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:1

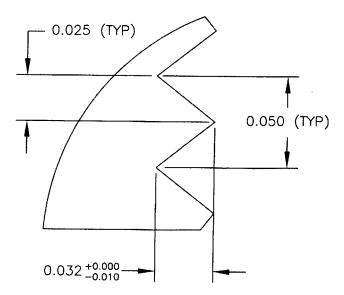
DETAIL A: SCALE 2:1 VIEW ROTATED





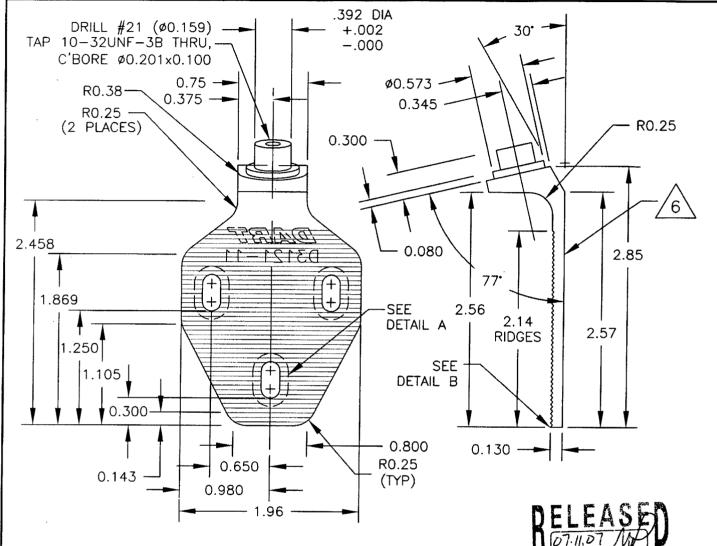
SECTION C-C

DETAIL B: RIDGE DETAIL PARTIAL SECTION SCALE 1:20





DESIGN	DRAWN BY	DART AEROS HAWKESBURY, ONT	-
CHECKED	APPROVED,	DRAWING NO.	REV. E
4		D3121	SHEET 4 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:1



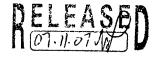
D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005





DESIGN	DRAWN BY	DART AEROSI HAWKESBURY, ONTA	
CHECKED	APPROVED	DRAWING NO.	rev. e
#	 	D3121	SHEET 5 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2



DAVBT!

D3121-13

1.220 - 1.800 ·

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-SEE

2.63

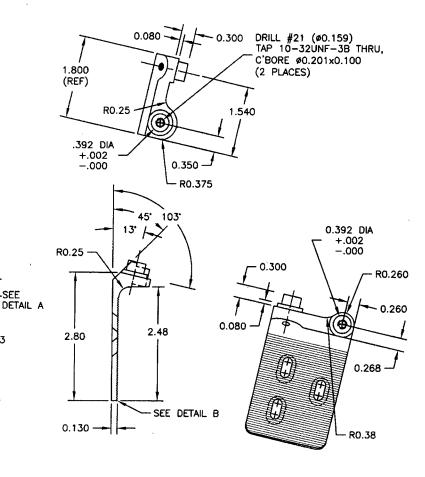
<u> 6\</u>

0.400 -

1.280

0.960

0.330



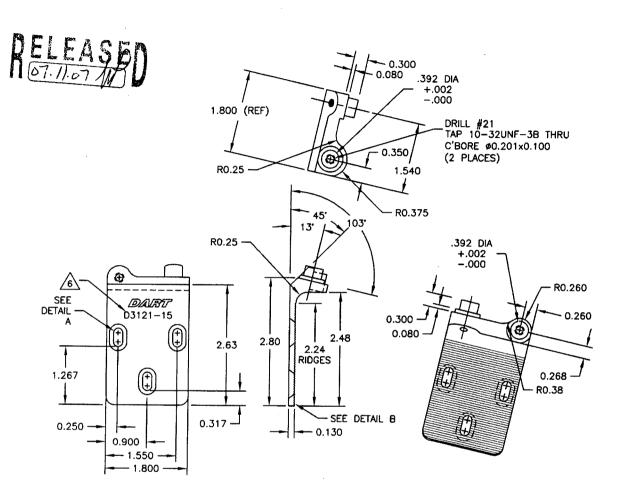
D3121-13 BRACKET (SHOWN) D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE STRENGTH = 150 ksi MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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	DESIGN A DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
	CHECKED	APPROVED	DRAWING NO.	REV. E	
i	91		D3121	SHEET 6 OF 10	
	DATE		TITLE	SCALE	
	07.11.07		BRACKET ASSEMBLY	1:2	



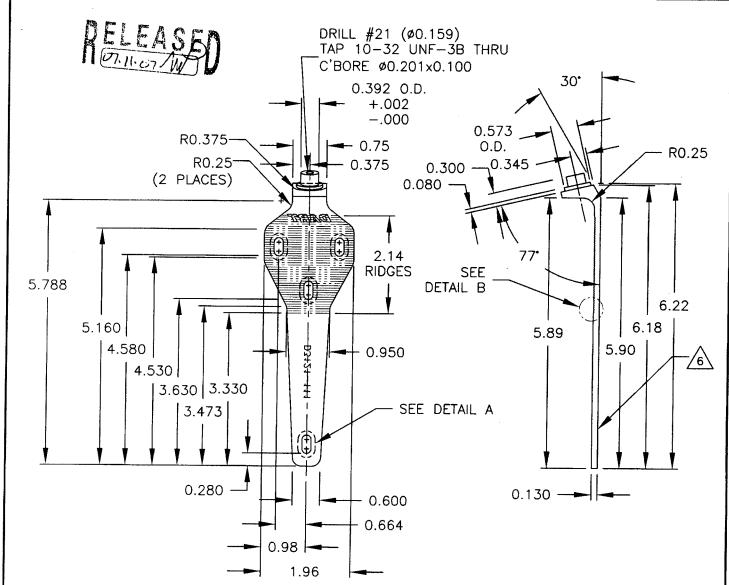
D3121-15 BRACKET (SHOWN) D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE = 150 ksi
 MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DESIGN A DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	
#		D3121	SHEET 7 OF 10	
DATE		TITLE	SCALE	
07.11.07		BRACKET ASSEMBLY	1:2	



D3121-111 BRACKET

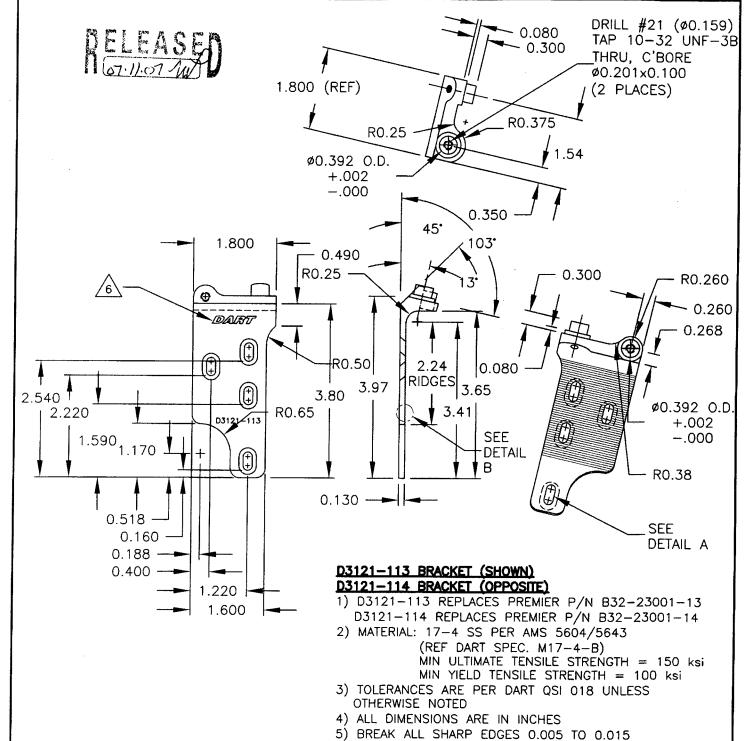
- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi

MIN YIELD TENSILE = 100 ksi

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005



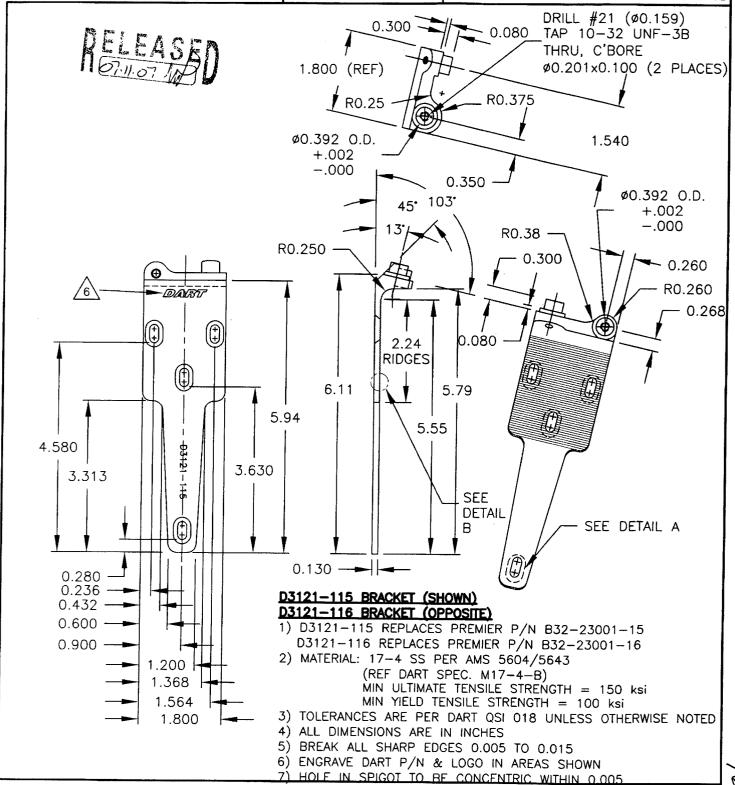
DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	
4	1	D3121	SHEET 8 OF 10	
DATE		TITLE	SCALE	
07.11.07		BRACKET ASSEMBLY	1:2	



6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005



DESIGN A DRAWN BY		/ _	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
	CHECKED	APPROVED	DRAWING NO.	REV. E	
	98		D3121	SHEET 9 OF 10	
	DATE		TITLE	SCALE	
	07.11.07		BRACKET ASSEMBLY	1:2	



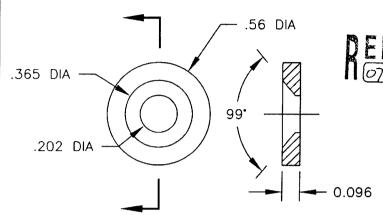
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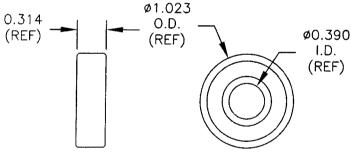


DESIGN DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
	CHECKED	APPROVED.	DRAWING NO.	REV. E	
	#	#	D3121	SHEET 10 OF 10	
	DATE		TITLE	SCALE	
	07.11.07		BRACKET ASSEMBLY	1:1	



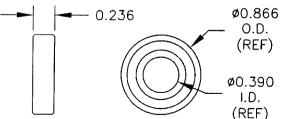
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCÈS ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



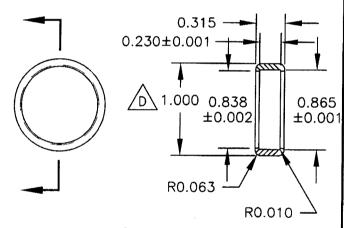
D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

0.375 TAP 10-32 UNF-3A PELEASE 0.080 0.050 TO 0.060

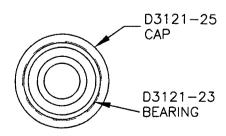
D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)

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96579



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19067

Purchase Order Date 2/11/13 PO Print Date 2/11/13

Page Number 1 of 1

Order From:

VC-MAI001

MAIN INDUSTRIAL SALES LTD.

1475, TES\$IER

HAWKESBURY, ON K6A 3S6

CA

Contact Name

Vendor Phone

613 632 3595

Vendor Fax

613 632 0262

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30 CAD

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

Line Nbr Reference

Revision ID

Description/ Mfg ID

Req Date/

Taxable Unit of Measure

Req Qty/ Ship Method

Unit Price

\$1.6200

Extended

Price

Vendor Part Number

6900ZZ

Bearing

2/12/13 Yes

100.00

Each

\$162.00

Special Last:

AS PER DWG D3121 REV. E

B96579

SKF P/N: 61900-2Z OR KML P/N: 6900-ZZ

PO Total:

\$162.00

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required YES

Change Nbr:

€ hauge Date: 2/11/13

MAIN INDUSTRIAL SALES LTD.

1475 TESSIER ST.

HAWKESBURY ON K6A 3S6

Phone: (613) 632-3595 Ext. Fax: (613) 632-0262

sales@mainindustrialsales.com

Packing Slip

DATE February 13, 2013
NUMBER 0000160233
CUSTOMER NO. DART

BILL TO:

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A-1K7 SHIP TO:

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7

(613) \$32-5200 Ext.

(613) 632-5200 Ext.

			(010) 002 0200 Ext.				
P.0	. NUMBER	SALESPERSON	ORDER I	DATE	REQ. DATE	ORDER NUMBER	
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PART NUM	BER				QUA	ANTITY	
DESCRIP	TION	LOCATION	UC	M	REQ. , SH	IIPPED B.O.	
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